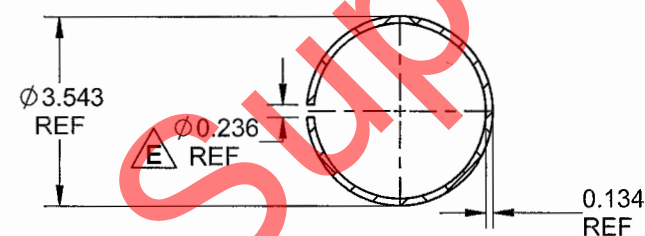


D135-1027-151 STD HEIGHT FWD CROSSTUBE



SECTION A-A
SCALE 2X

RELEASED

2019 OCT 28
EN 14-84

NOTES:

- 1) MATERIAL: MAKE FROM D6025-120
STRAIGHT LENGTH = 111.46 ±0.06 (BEFORE BENDING / TRIMMING)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 13.88 lbs
- 8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25.
- 9) HOLES TO BE ALIGNED WITHIN 0.005 IN RELATION TO THE HOLE ON OPPOSITE SIDE OF CROSSTUBE
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.
- 12) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.

E	HOLE Ø0.236 ADDED. REASON: FOR INSTALLATION OF OPTIONAL OEM CARGO HOOK FITTING	MW	19.09.11
D	MOVED STEP HOLES DIM 9.30 WAS 8.93	ZF	18.10.04
C	ZONE C2 3.15 DIM WAS 4.00. ACCORDINGLY 19.65 WAS 20.46 AND 79.62 WAS 80.18. REASON: D5424-1 SPACER DELETED FROM INSTALLATION.	ML	17.10.30
B	QTY (4) Ø0.472 WAS Ø0.313, 2.75 WAS 1.57, 8.93 WAS 9.80. REASON: DESIGN UPDATE	ML	17.05.25
A	NEW ISSUE	ML	17.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MW		
CHECKED	ZF	DRAWING NO. D135-1027-151	
MFG. APPR.	DD	REV. E SHEET 1 OF 1	
APPROVED	NO	TITLE STD HEIGHT FWD XTUBE	
DE APPR.	CP	SCALE NTS	
DATE	19.09.11	<small>COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED